

IN THE CLAIMS:

1. (Currently Amended) A friction welding machine comprising:

~~with a frame (2), with;~~

a first headstock (5), which has a spindle (8) with a workpiece holder (22) and with a spindle drive (12); and

5 ~~with a feed drive (25) with a second workpiece holder (22), characterized in that said friction welding machine (1) has~~

a second headstock (6) with a spindle (9), with a spindle drive (13) and with said second workpiece holder (22), wherein said second headstock (6) is mounted axially movably at said frame (2) and is connected to said feed drive (25).

2. (Currently Amended) A friction welding machine in accordance with claim 1, ~~characterized in that~~ wherein said first headstock (5) is arranged stationarily at said frame (2).

3. (Currently Amended) A friction welding machine in accordance with claim 1 ~~or 2~~, ~~characterized in that~~ wherein said spindles (8, 9) have different sizes.

4. (Currently Amended) A friction welding machine in accordance with claim 3, ~~characterized in that~~ wherein said spindle (9) of said second spindle drive (13) is smaller than said other spindle (8).

5. (Currently Amended) A friction welding machine in accordance with ~~one of the above~~ claims claim 1, characterized in that wherein said second spindle drive (13) is weaker than said first spindle drive (12).

6. (Currently Amended) A friction welding machine in accordance with ~~one of the above~~ claims claim 1, characterized in that wherein at least one said workpiece holder (22) has a bridge (10, 11) supporting the forge force and the torque.

7. (Currently Amended) A friction welding machine in accordance with ~~one of the above~~ claims claim 6, characterized in that wherein a workpiece holder (22) is mounted rigidly at said bridge (10, 11).

8. (Currently Amended) A friction welding machine in accordance with ~~one of the above~~ claims claim 6, characterized in that wherein said bridge (10, 11) has a carrying body (33) and a positive-locking support (34) for connection to at least one of said first headstock (5, 6) and second headstock.

9. (Currently Amended) A friction welding machine in accordance with ~~one of the above~~ claims claim 8, characterized in that wherein said positive-locking connection (34) has said pins (35) and said openings (36) that engage each other at said carrying body (33) and at least one of said first headstock and second headstock (5, 6).

10. (Currently Amended) A friction welding machine in accordance with ~~one of the above claims~~ claim 1, ~~characterized in that~~ wherein at least one said workpiece holder (22) is detachably connected to a spindle (8, 9).

11. (Currently Amended) A friction welding machine in accordance with ~~one of the above claims~~ claim 6, ~~characterized in that~~ wherein said spindles (8, 9) and said bridge (10, 11) have said similar workpiece holders (22).

12. (Currently Amended) A friction welding machine in accordance with ~~one of the above claims~~ claim 1, ~~characterized in that~~ wherein said second headstock (6) has a traveling carriage (7), which is mounted and guided in a positive-locking manner at a carriage guide (31) at said frame (2) along ~~said~~ a direction of feed (32).

13. (Currently Amended) A friction welding machine in accordance with ~~one of the above claims~~ claim 1, ~~characterized in that~~ wherein said feed drive (25) is mounted and supported at a column (4) of said frame (2).

14. (Currently Amended) A friction welding machine in accordance with ~~one of the above claims~~ claim 13, ~~characterized in that~~ wherein said column (4) and said stationary headstock (5) are connected by one or more said tie rods (29).

15. (Currently Amended) A friction welding machine in accordance with ~~one of the~~
~~above claims~~ claim 1, ~~characterized in that~~ wherein said feed drive (25) has one or more said
cylinders (26, 28).

16. (Currently Amended) A friction welding machine in accordance with ~~one of the~~
~~above claims~~ claim 1, ~~characterized in that~~ wherein said spindle drives (12, 13) have said
electric drive motors (14, 15).

17. (Currently Amended) A friction welding machine in accordance with ~~one of the~~
~~above claims~~ claim 1, ~~characterized in that~~ wherein at least one said spindle drive (12, 13) has
~~said~~ settable flywheel masses (17).

18. (Currently Amended) A friction welding machine in accordance with ~~one of the~~
~~above claims~~ claim 1, ~~characterized in that~~ wherein said stationary spindle drive (12) has one
or more ~~said~~ additional flywheel masses (18) that can be coupled.

19. (Currently Amended) A process for operating a friction welding machine (1), the
process comprising:

providing the welding machine with a plurality of ~~said~~ headstocks (5, 6) with ~~said~~
spindles (8, 9), ~~said~~ spindle drives (12, 13) and ~~said~~ workpiece mounts (22) ;

movably mounting one of said headstocks to provide a movably mounted headstock;

providing as well as with a feed drive (25) for [[a]] moving the movably mounted headstock (6), ~~characterized in that~~ ; and
providing a bridge, wherein one of said [[a]] spindles (8, 9) is relieved of said axial force and welding forces [[F]] and [[the]] torque [[M]] with [[a]] the bridge (11) during [[the]] a welding operation.

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20. (Currently Amended) A process in accordance with claim 19, ~~characterized in that~~
wherein said workpiece mount (22) is removed from said spindle (8, 9) that is to be relieved, and said bridge (11) with a workpiece mount (22) attached thereto is placed over said spindle (8, 9) and connected to said headstock (5, 6) by means of a support (34).